

# LUFKIN TIME SAVER



### DECIMAL EQUIVALENTS OF LETTER SIZE DRILLS

[illegible]

# DECIMAL EQUIVALENTS OF NUMBER SIZE DRILLS

No.	Size of Drill in Inches	No.	Size of Drill in Inches
1	.2280	21	.1590
2	.2210	22	.1570
3	.2130	23	.1540
4	.2090	24	.1520
5	.2055	25	.1495
6	.2040	26	.1470
7	.2010	27	.1440
8	.1990	28	.1405
9	.1960	29	.1360
10	.1935	30	.1285
11	.1910	31	.1200
12	.1890	32	.1160
13	.1850	33	.1130
14	.1820	34	.1110
15	.1800	35	.1100
16	.1770	36	.1065
17	.1730	37	.1040
18	.1695	38	.1015
19	.1660	39	.0995
20	.1610	40	.0980

No.	Size of Drill in Inches	No.	Size of Drill in Inches
41	.0960	61	.0390
42	.0935	62	.0380
43	.0890	63	.0370
44	.0860	64	.0360
45	.0820	65	.0350
46	.0810	66	.0330
47	.0785	67	.0320
48	.0760	68	.0310
49	.0730	69	.0292
50	.0700	70	.0280
51	.0670	71	.0260
52	.0635	72	.0250
53	.0595	73	.0240
54	.0550	74	.0225
55	.0520	75	.0210
56	.0465	76	.0200
57	.0430	77	.0180
58	.0420	78	.0160
59	.0410	79	.0145
60	.0400	80	.0135



## SCREW THREADS AND TAP DRILL SIZES

**NPT** = American National Taper Pipe Thread

Size of Tap	Thds. Per Inch	Tap Drill
1/8	27	R
3/8	18	7/16
1/2	14	5/8
3/4	14	7/8
1	11 1/2	1 1/8
1 1/4	11 1/2	1 1/2
1 1/2	11 1/2	1 3/4
2	11 1/2	2 1/8
2 1/2	8	2 1/2
3	8	3 1/4

\* S. A. E. only  
**NPT** PIPE THREADS

Size of Tap	Thds. Per Inch	Tap Drill
1/4	28	3
5/16	24	1
3/8	24	Q
7/16	20	2 1/4
1/2	20	2 3/4
5/8	18	3 1/4
3/4	18	3 3/4
* 1 1/8	16	4 1/2
1 1/4	16	5 1/8
1 1/2	14	6 1/4
1 3/4	14	7 1/8
2	12	8 1/4

**NF** OR S. A. E. STANDARD SCREWS

Tap drills allow approximately 75% full thread

Size of Tap	Thds. Per Inch	Tap Drill	Body Drill
1	64	53	47
2	56	50	42
3	48	47	37
4	40	43	31
5	40	38	29
6	32	36	27
8	32	29	18
10	24	25	9
12	24	16	2

**NC** OR A. S. M. E. SPECIAL MACHINE SCREW

\* A. S. M. E. only

Size of Tap	Thds. Per Inch	Tap Drill	Body Drill
2	64	50	42
3	56	45	37
4	48	42	31
5	44	37	29
6	40	33	27
8	36	29	18
10	32	21	9
* 10	30	22	9
12	28	14	2

**NF** OR A. S. M. E. STD. MACHINE SCREWS